



Dart Aerospace Ltd.
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Canada

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D4125-1
Job Sheet 195830



Part No: D4125-1

Job Qty: 4 pcs

Part Name: Fwd Sediment Bowl



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/31/19

Job Tracking No:

Due Date: 6/17/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEET 1 IPP Rev:A 10.07.21 new issue DD ver:EC IPP Rev:B 11/12/05 as per dwg. rev.B JFS
ver:DD IPP REV:C 15.03.04 remove alodine and add holes DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	6/17/19	6/17/19	0.00	0.01	Bandsaw - 1		19-06-17
105	HAAS 5 Axis - B4B	4 pcs	6/17/19	6/17/19	0.96	16.00	HAAS - 5 - B4B		19-06-17
110	QC 2	4 pcs	6/17/19	6/17/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		19-06-17
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

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Container No: S190829



Part: D4125-1
Job No: 195830
Serial No/Batch: S190829
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 06/17/19

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NCR: 19-7236

120 QC 8	4 pcs	6/17/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	normal 17/06/18
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Packaging 3-1 - Stock - B4B 4 pcs		6/17/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

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				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	4 pcs	6/17/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-85 JUN 18 2019

Part Op 100 - (Bandsaw) 1-Cut Blank at 13.375"
Descriptions: 105 - (HAAS CNC vertical machine #5) Machined as per folio FB078 Rev: AA Dwg: E
110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
150 - (Identify as per dwg & Stock Location: _____) LOCATION: WA003
160 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X08.000	6061-T6 Bar 2.00" X 8.00" (Cut In 4Ft Section)	4.4600 ft (1.115 ea)	100-Bandsaw - 1	5110497

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.000X08.000	4	11	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Sediment Bowl	0.140Inches ± 0.030	0.170 0.110		.140
2	Fwd Sediment Bowl	0.260Inches ± 0.030	0.290 0.230		.260
3	Fwd Sediment Bowl	0.200Inches ± 0.030	0.230 0.170		.190
4	Fwd Sediment Bowl	0.200Inches ± 0.030	0.230 0.170		.200
5	Fwd Sediment Bowl	6.230Inches ± 0.030	6.260 6.200		6.234
6	Fwd Sediment Bowl	3.560Inches ± 0.030	3.590 3.530		3.560
7	Fwd Sediment Bowl	2.610Inches ± 0.030	2.640 2.580		2.615
8	Fwd Sediment Bowl	0.250Inches ± 0.030	0.280 0.220		.250
9	Fwd Sediment Bowl	0.250Inches ± 0.030	0.280 0.220		.250
10	Fwd Sediment Bowl	11.870Inches ± 0.030	11.900 11.840		11.870
11	Fwd Sediment Bowl	0.310Inches ± 0.030	0.340 0.280		.310
12	Fwd Sediment Bowl	6.010Inches ± 0.030	6.040 5.980		6.010
13	Fwd Sediment Bowl	11.980Inches ± 0.030	12.010 11.950		11.990
14	Fwd Sediment Bowl	0.060Inches ± 0.030	0.090 0.030		.090
15	Fwd Sediment Bowl	0.430Inches ± 0.030	0.460 0.400		.425
16	Fwd Sediment Bowl	2.180Inches ± 0.030	2.210 2.150		2.175
17	Fwd Sediment Bowl	7.156Inches ± 0.005	7.161 7.151		7.155
18	Fwd Sediment Bowl	0.257Inches + 0.006 - 0.001	0.263 0.256		.258
19	Fwd Sediment Bowl	1.370Inches ± 0.030	1.400 1.340		1.399
20	Fwd Sediment Bowl	0.348Inches + 0.006 - 0.001	0.354 0.347		.348
21	Fwd Sediment Bowl	2.990Inches ± 0.030	3.020 2.960		2.992
22	Fwd Sediment Bowl	0.300Inches ± 0.030	0.330 0.270		.299

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md 5 July 2019

Entered:

Date: 19-06-12

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

19-7236

Route update only



Job: 195830		DISPOSITION		DEPARTMENT/PROCESS				Route update only	
Part No. 04125-1		Rework ☒ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date:		Sequence #:		QTY Affected:		MRB (QSI042) ☒ DAS 55 JUN 13 2019 9-89			
Description Work Order Deviation				Disposition				Completed By JUL 19/06/10	
Ø.3413" Long Drill jammed & Broke in the part				Scrap & Replace Batch: S110497				Lead hand / Supervisor JAN LUC M. JUN 13 2019	
QC / QA Coordinator DAS 68 9-89 JUN 13 2019									
Root Cause		FAULT CATEGORY							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	